

Date: Thursday, 3/30/2006 8:34:45 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 26438		
Estimate Number	: 10466		
P.O. Number	: N/A	Part Number	: D33891
This Issue	: 3/30/2006 S.O. No. : N/A	Drawing Number	: D3389 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 26437	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/20/2006
Checked & Approved By	: <u>06.03.30</u>	Qty:	7 Um: Each
Comment	: Est Rev:A 05-08-31 New issue KJJ/JLM Est Rev:B 06-02-08 As per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -1" Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Ext'n -1" Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	B19074

Pm' 06-04-03 (7)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

Pm' 06-04-03 (7)

2-Drill pilot holes using DT8785 as per Dwg D3389

Pm' 06-04-03 (7)

3-Open 1X .257" Dia Hole

Pm' 06-04-03 (7)

4-Open Remaining holes to finish size as per Dwg D3389

Pm' 06-04-03 (7)

5-Deburr

Pm' 06-04-03 (7)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

BE 06-04-03

(7)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06 04 05

(7)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LS Date: 06/07/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 412 WEB

Job Number: 26438

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/04/05 (7)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46 DP 06-4-10

(7)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/04/05 (7)

Job Completion



U 06.04.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

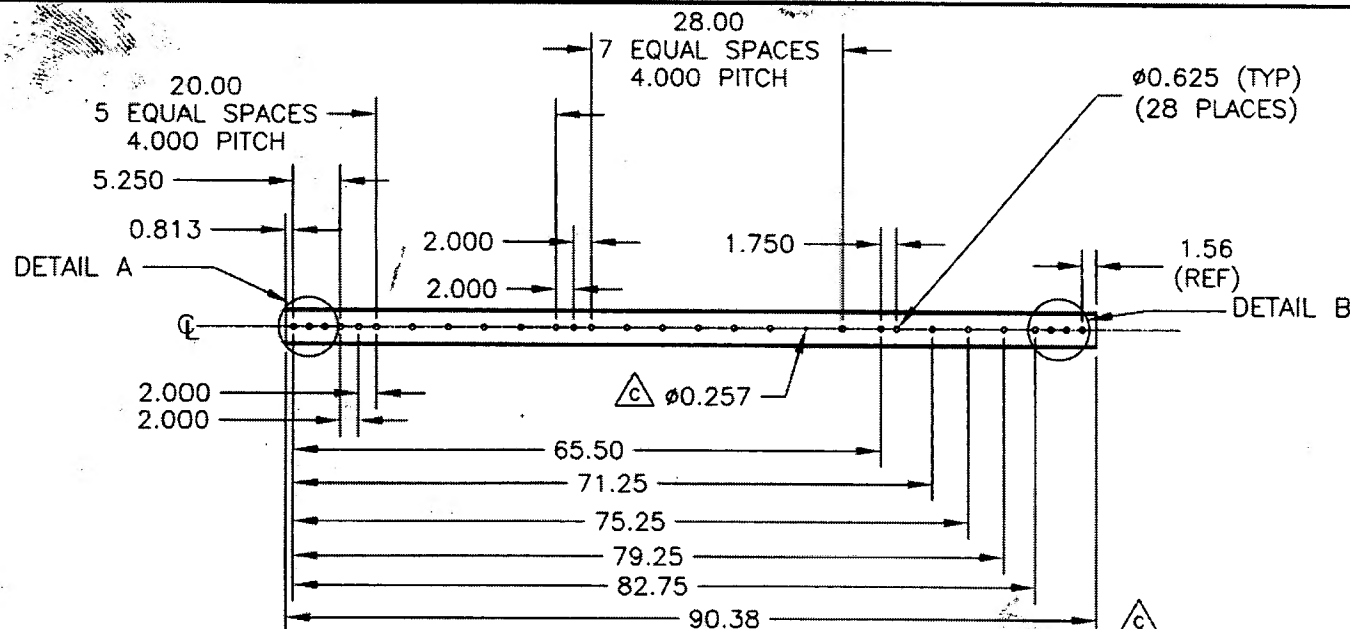
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

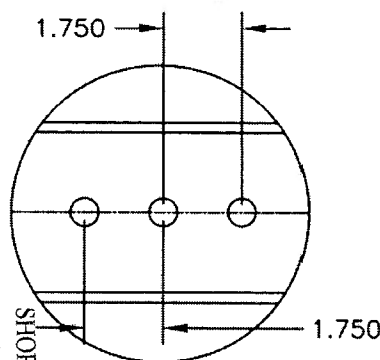


RELEASE
06.01.23

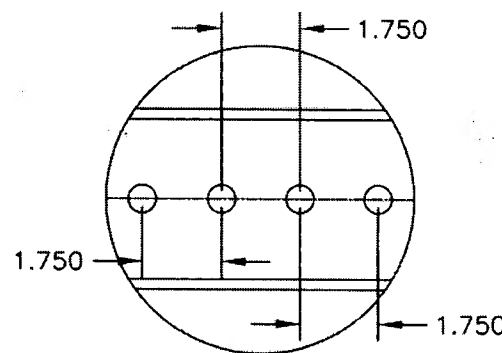
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.01.23	05.02.07	05.06.13	06.01.23
A		05.02.07	05.06.13	06.01.23
B		05.02.07	05.06.13	06.01.23
C		05.02.07	05.06.13	06.01.23
D3389-1 412 WEB				NEW ISSUE
D3389-1 412 WEB				UPDATE DIMENSIONING
D3389-1 412 WEB				DECREASE OVERALL LENGTH, MODIFY HOLE
D3389-1 412 WEB				SCALE
D3389-1 412 WEB				1:20



D3389-1 DRILLING DETAIL



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26438

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED